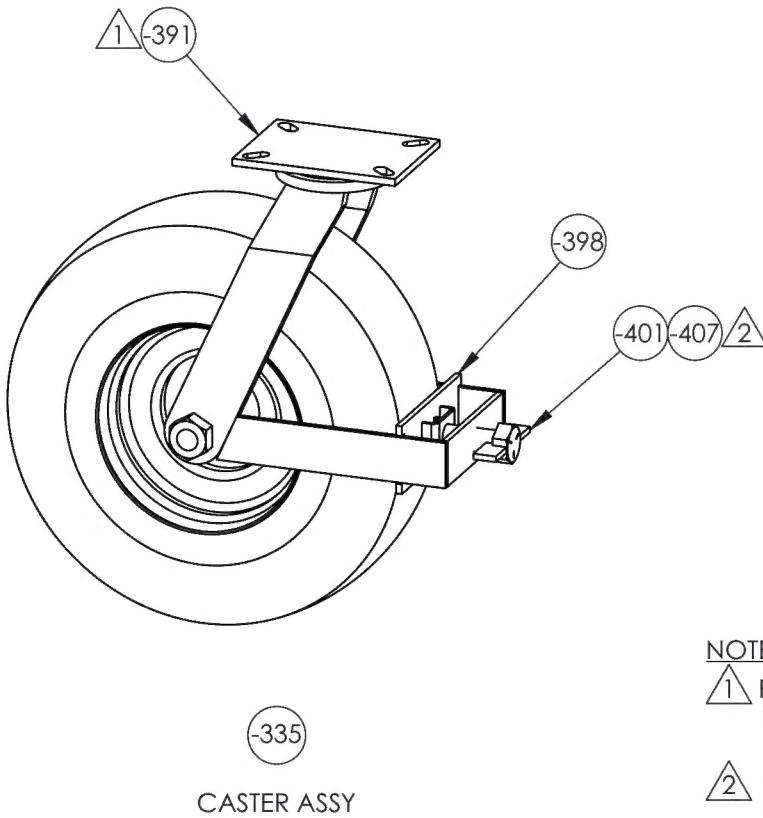


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION			4/26/2017	SM	JAG



NOTES:

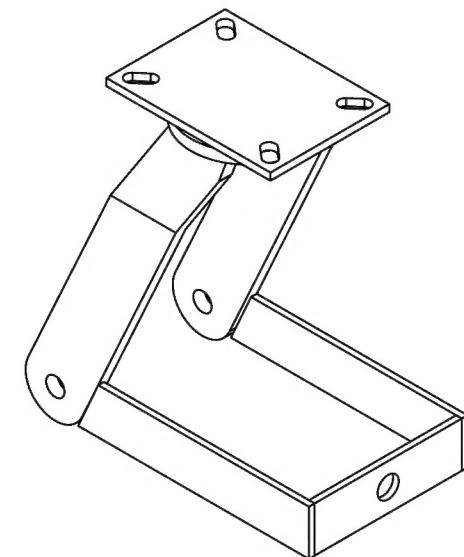
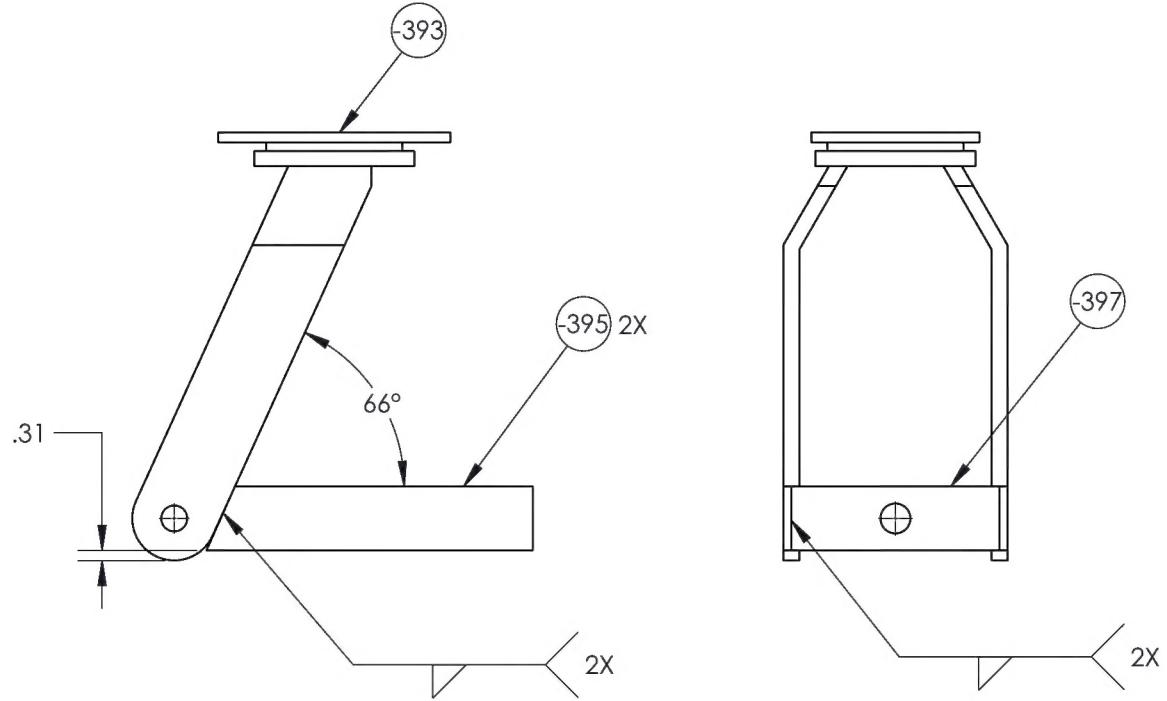
- 1 REMOVE TIRE AND AXEL FROM -391 PRIOR TO WELDING AND PLATING. RE-INSTALL AFTER PLATING.
- 2 INSTALL -407 SO THAT -401 CAN STILL ROTATE FREELY.

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		X		-391	1	CASTER WELDMENT			2
		1		-393		SWIVEL CASTER		(MCMASTER-CARR - 28035T12) MODIFIED	2
		2		-395		BRAKE SUPPORT	A36/1018/1020 HR		3
		1		-397		THREADED BRAKE PLATE	A36/1018/1020 HR		4
X				-398	1	BRAKE PLATE WELDMENT			5
1				-399		BRAKE PLATE	A36/1018/1020 HR		6
1				-400		BRAKE PLATE TAB	A36/1018/1020 HR		7
X				-401	1	BRAKE BOLT WELDMENT			8
2				-403		BRAKE BOLT TAB	A36/1018/1020 HR		9
1		B/O		-405		BRAKE BOLT	STEEL	1-14 x 3 (MCMASTER-CARR # 92865A524)	8
		B/O		-407	1	SPRING PIN	STEEL	1/4 x 1-1/2 (MCMASTER-CARR # 90692A746)	1
ASSM -401	ASSM -391								

 <p>DART AEROSPACE</p>		SUPPORT DOLLY, TAILBOOM RB T102012-335		REV		
				1		
MAT'L HEAT TREAT FINISH SPEC				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓		
DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT				1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL		
		SCALE	1:8	DATE 11/15/2016		
				SHEET 1 OF 9		

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REVISIONS						
REV	ECR	DESCRIPTION			DATE	INITIAL



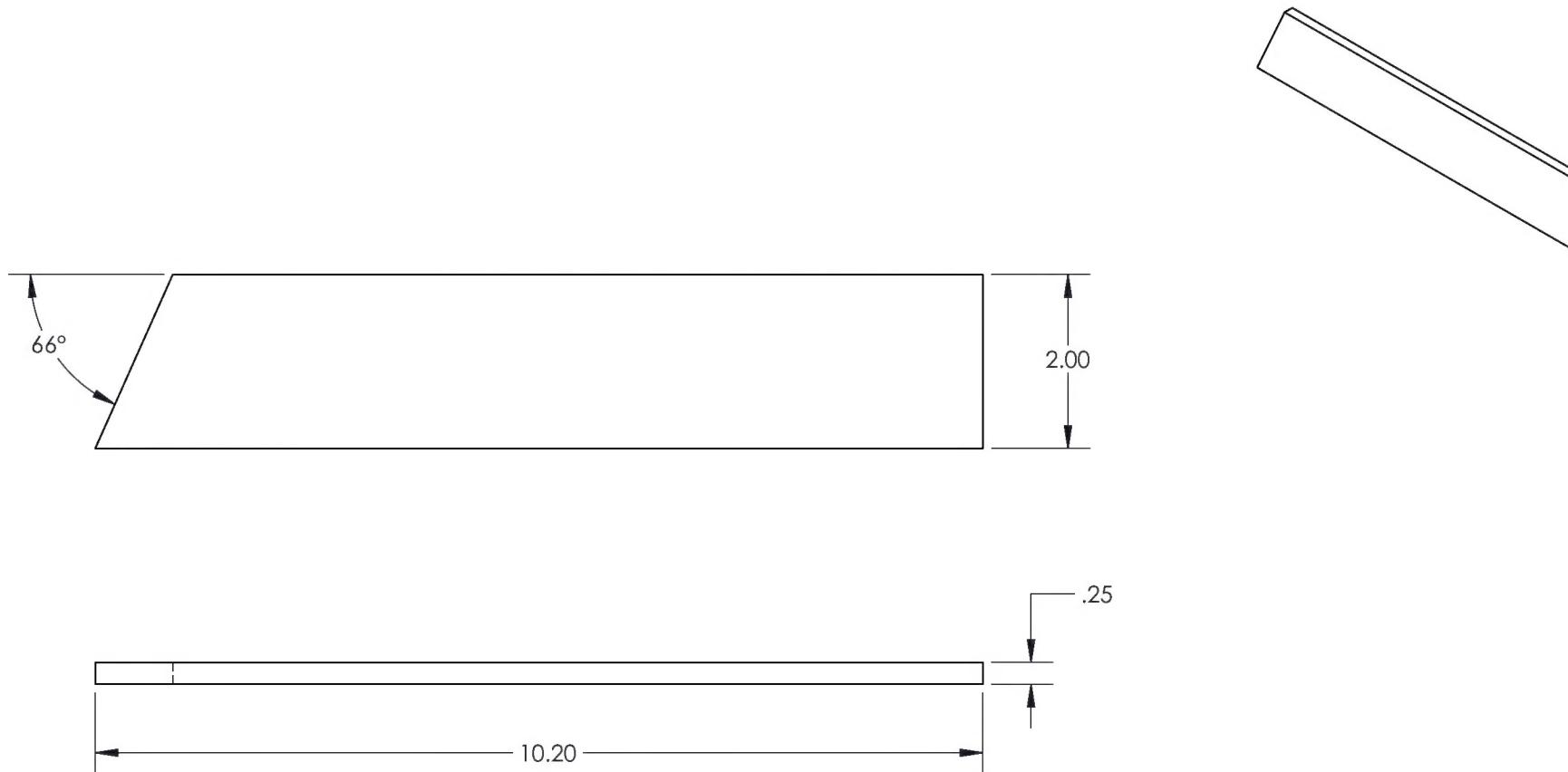
-391

CASTER WELDMENT

 DART AEROSPACE	
TITLE	SUPPORT DOLLY, TAILBOOM
DWG NO.	RB T102012-391
REV	1
MAT'L HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2 DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XXX $\pm .010$ FRACTIONS $\pm 1/8$ XX $\pm .03$ ANGLES $\pm 1^\circ$ X $\pm .1$ SURFACES = 125/ <ol style="list-style-type: none"> 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 	
SCALE	1:6
DATE	11/15/2016
SHEET 2 OF 9	

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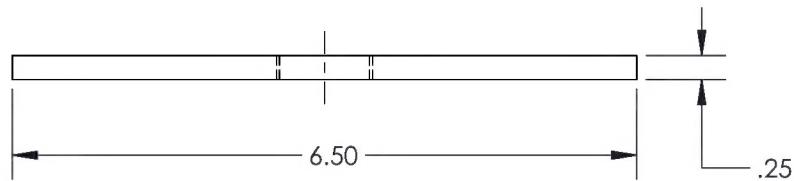
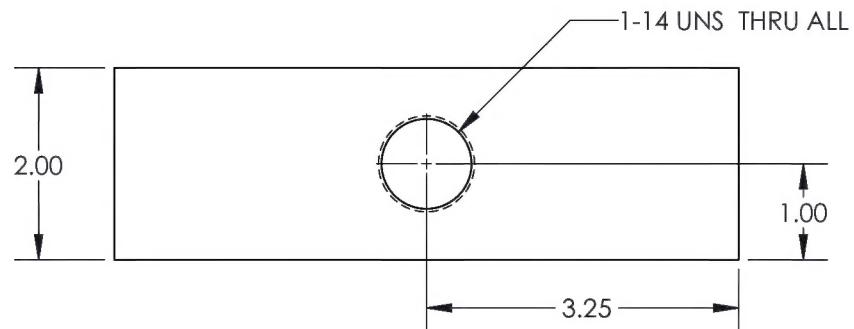
-395

BRAKE SUPPORT

		TITLE	
SUPPORT DOLLY, TAILBOOM		DWG NO.	
RB T102012-395		REV	
1			
MATERIAL A36/1018/1020 HR		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH SEE -391 WELDMENT		.XX ± .03 ANGLES ± 1°	
SPEC		.X ± .1 SURFACES = 125 ✓	
DRAWN BY: MACKOVJAK		1. BREAK ALL SHARP EDGES	
CHECKED: CLOUGH		.015 x 45° OR .015R	
OPPS APPR: ANDERSON		2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY		AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER	
		ASME Y14.5M-2009	
SCALE 1:2		USED ON MODEL	
DATE 11/15/2016		212, 214B, 214ST, 412	
SHEET 3 OF 9			

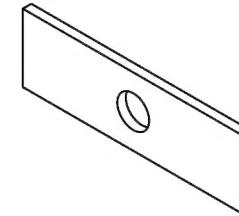
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-397

THREADED BRAKE PLATE



	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-397
MAT'L	A36/1018/1020 HR
HEAT	UNLESS OTHERWISE SPECIFIED
TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .010 FRACTIONS ± 1/8
SEE -391 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	X ± .1 SURFACES = 125 ✓
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	212,214B, 214ST, 412
SCALE	1:2
DATE	11/15/2016
SHEET 4 OF 9	

1

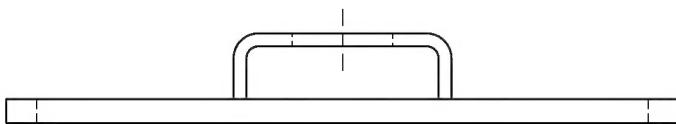
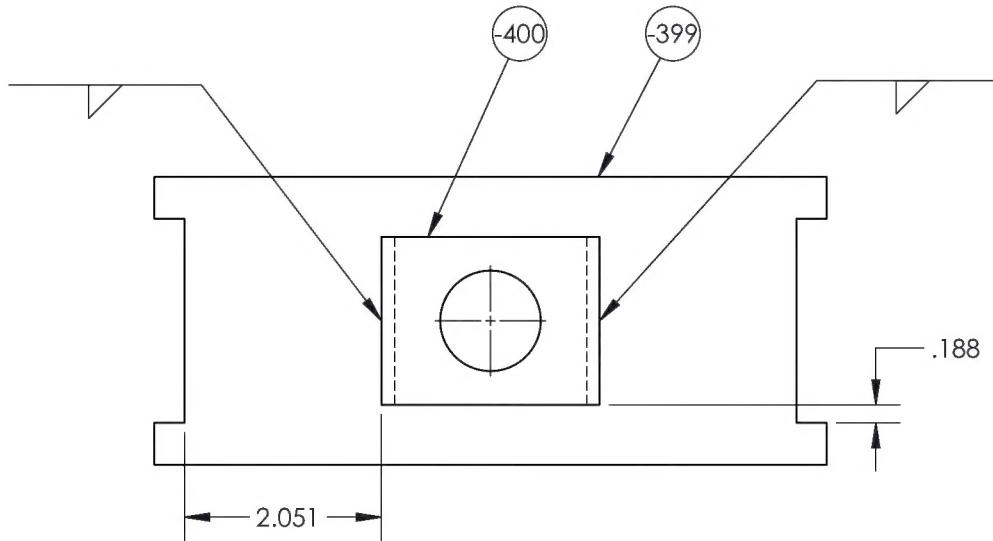
REVISIONS

DESCRIPTION

DATE INITIAL APPROVED

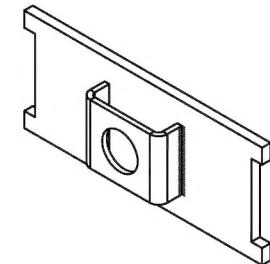
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-398

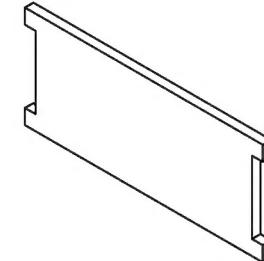
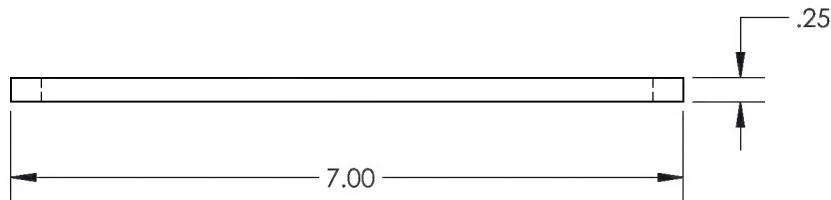
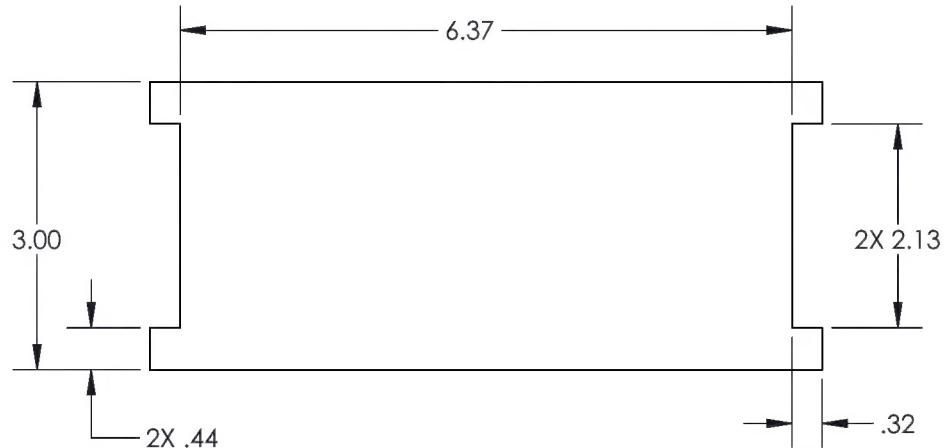
BRAKE PLATE WELDMENT



DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-398	
REV	1
MAT'L HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° X ± .1 SURFACES = 125 ✓	
DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SCALE 1:2	DATE 11/15/2016
SHEET 5 OF 9	

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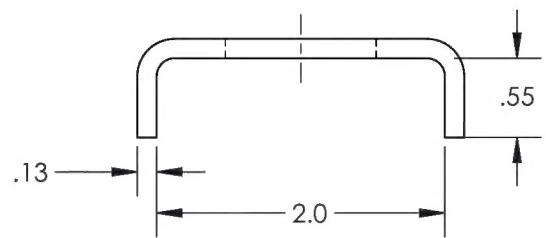
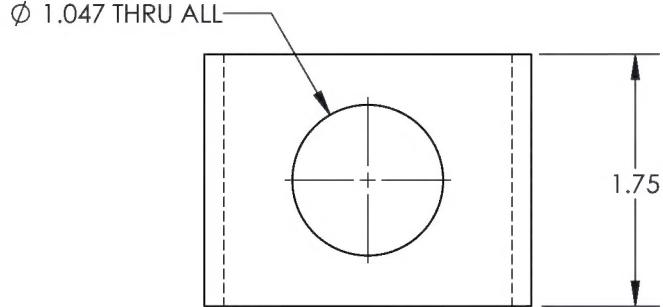
-399

BRAKE PLATE

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-399	
REV	1
MAT'L A36/1018/1020 HR	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	.X ± .1 SURFACES = 125 ✓
SPEC	
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
212, 214B, 214ST, 412	
SCALE	1:2
DATE	11/15/2016
SHEET 6 OF 9	

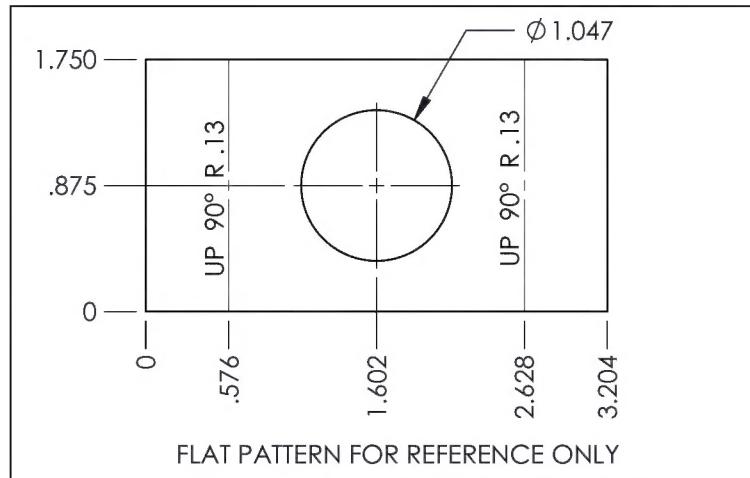
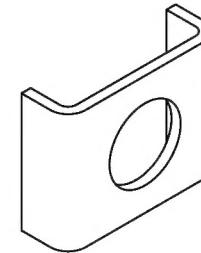
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-400

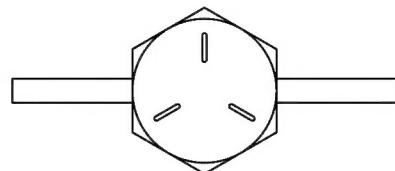
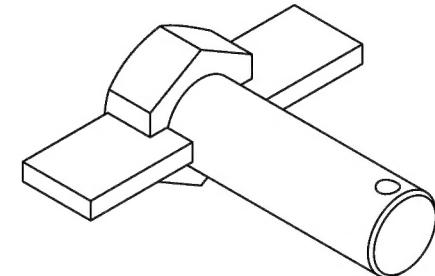
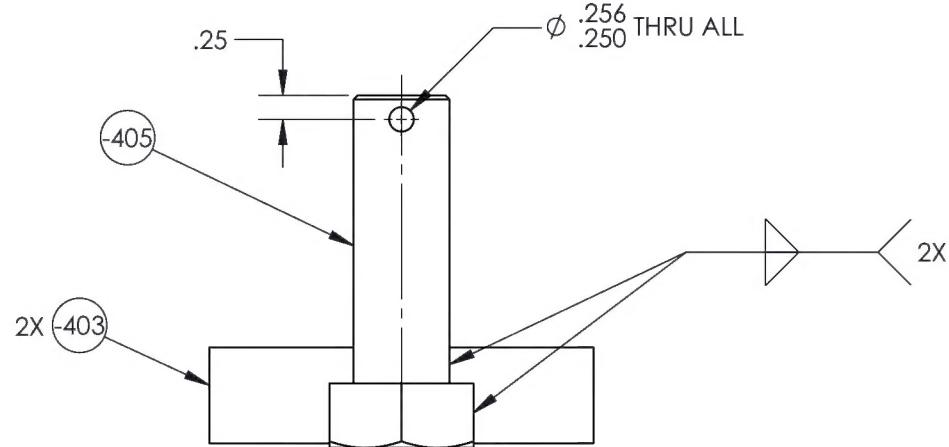
BRAKE PLATE TAB



DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-400	
REV 1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL	
212, 214B, 214ST, 412	
SCALE	3:4
DATE	11/15/2016
SHEET 7 OF 9	

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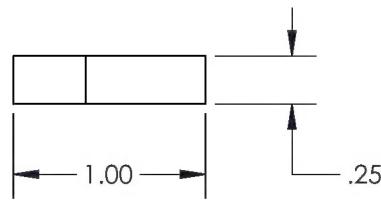
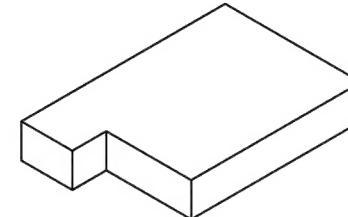
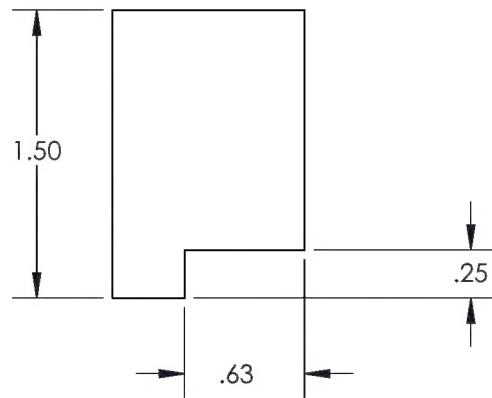
-401

BRAKE BOLT WELDMENT

	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO.	RB T102012-401
REV	1
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .010 FRACTIONS ± 1/8
TREAT	.XX ± .03 ANGLES ± 1°
FINISH	X ± .1 SURFACES = 125
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	MACKOVJAK
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	212, 214B, 214ST
SCALE	1:2
DATE	11/15/2016
SHEET 8 OF 9	

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-403

BRAKE BOLT TAB

DART AEROSPACE	
TITLE	
SUPPORT DOLLY, TAILBOOM	
DWG NO.	
RB T102012-403	
REV 1	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .010 FRACTIONS ± 1/8	
.XX ± .03 ANGLES ± 1°	
X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: MACKOVJAK	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
USED ON MODEL	
212, 214B, 214ST, 412	
SCALE	1:1
DATE	11/15/2016
SHEET 9 OF 9	